

# Work Order ID 81119

**\*81119\***

Page 1

March-08-12 8:53:23 AM

Item ID: D412-630-033

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Heli Access Step LH Folding

Stop

**\*NS2\***

Start Date: 08/03/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 22/03/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals: Process Plan: MLS

Date: 12/03/09 Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN D412-630

Rev M

100

0.00

**\*100\***

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & create labels per PPP D412-630-033 CHG003

*Handwritten:* JCS MLS 12-6-14  
(4)

*Handwritten:* 2/6/14

110

0.00

**\*110\***

Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg D412-630 p.14

Coat all hardware with LPS3 rust inhibitor

A/R LPS3 batch: M119 317

COAT exposed HARDWARE WITH LPS PROCYON

A/R LPS PROCYON BATCH: M114526

*Handwritten:* 12/06/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
<b>*120*</b>		0.00							
QC	Memo								
Quality Control									
130	Pick Kit	0.00							
<b>*130*</b>		0.00							
Packaging	Memo								
Packaging									
140	QC4- 100% Inspect kits for completeness	0.00							
<b>*140*</b>		0.00							
QC	Memo								
Quality Control									

8/26/13

4  
4

4  
4

12/6/13  
12/06/13 JB

8/26/14

4  
4

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**\*4\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

0.00

**\*150\***

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-630-033

Location: 11PPP Rev: A4212/6/14

160

0.00

**\*160\***

QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

12/6/18MCS 12/06/15

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Parent Item Name: Heli Access Step LH Folding

Start Date: 08/03/2012

Required Date: 22/03/2012

Start Qty: 4.00

Required Qty: 4.00

## Comments:

IPP Rev:A New Issue 06-11-08 JLM  
 IPP rev B ecn 1019, added d2807-041 EC verified by:DD  
 IPP rev :C 11.01.06 added route seq ID DD vef:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2012-107

Manufactured

No

110

Each

21.0000

1

4

\*D2012-107\*

Clevis

\*\*

B82039

### Location

### Loc Qty

### Loc Code

ST004

21

75057

21

D2803-041

Manufactured

No

110

Each

3.0000

1

4

\*D2803-041\*

Bracket Assembly

\*\*

B82375

### Location

### Loc Qty

### Loc Code

ST147

3

74804

1

77931

1

79184

1

D2804-041

Manufactured

No

110

Each

3.0000

1

4

\*D2804-041\*

Bracket Assembly

\*\*

B12/06/13

### Location

### Loc Qty

### Loc Code

GA

4

ST

-4

ST148

1

79181

1

ST149

2

79523

2

B83935

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Start Qty: 4.00

Required Qty: 4.00

D2807-041

Manufactured No

110 Each

19.0000

2 8

**\*D2807-041\***

Door prop

\*\*

B83895

Location

Loc Qty

Loc Code

ST018

19

60540

2

68494

5

80165

12

D2813

Manufactured No

110 Each

45.0000

2 8

**\*D2813\***

Washer

\*\*

B83481

Location

Loc Qty

Loc Code

ST018

45

69386

1

79691

24

80848

20

D3562-041

Manufactured No

110 Each

0.0000

1 4

**\*D3562-041\***

Step Assembly, LH

D3395-1

Manufactured No

110 Each

13.0000

4 16

**\*D3395-1\***

Bushing

\*\*

B82021  
B83482  
B85431  
12/6/13  
12/6/14

Location

Loc Qty

Loc Code

ST041

13

71563

13

(1X)

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item Name: Heli Access Step LH Folding

Start Date: 08/03/2012

Required Date: 22/03/2012

Start Qty: 4.00

Required Qty: 4.00

AN3C21A

Purchased

No

110

Each

72.0000

2

\*AN3C21A\*

\*\*

BOLT

Location

Loc Qty

Loc Code

ST352

72

109148

2

119798

50

120781

20

AN8C16

Purchased

No

110

Each

50.0000

2

\*AN8C16\*

\*\*

Bolt

Location

Loc Qty

Loc Code

ST343

50

106066

2

120578

16

120748

12

120832

20

AN310C8

Purchased

No

110

Each

38.0000

2

\*AN310C8\*

\*\*

Nut

Location

Loc Qty

Loc Code

ST344

38

118378

2

120308

6

120644

10

120769

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item Name: Heli Access Step LH Folding

Start Date: 08/03/2012

Required Date: 22/03/2012

Start Qty: 4.00

Required Qty: 4.00

MS24665-302

Purchased

No

110

Each

213.0000

6

24

\*MS24665-302\*

Cotter Pin

\*\*

24

Location

Loc Qty

Loc Code

ST309

213

117460

13

120521

200

NAS1515H3

Purchased

No

110

Each

256.0000

4

16

\*NAS1515H3\*

Washer

\*\*

24

Location

Loc Qty

Loc Code

ST277

256

118078

6

118384

11

119438

4

120142

45

120518

90

120770

100

NAS1515H5L

Purchased

No

110

Each

82.0000

4

16

\*NAS1515H5I \*

WASHER

\*\*

2x  
1x  
3x  
16 3x

m121444

(16)  
m121652  
sp 121614

Location

Loc Qty

Loc Code

FG

40

103691

40

ST277

42

119902

42

2x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*D412-630-033\***

Parent Item Name: Heli Access Step LH Folding

Start Date: 08/03/2012

Required Date: 22/03/2012

Start Qty: 4.00

Required Qty: 4.00

NAS1515H8

Purchased

No

110

Each

67.0000

4

16

**\*NAS1515H8\***

Washer

\*\*

M121068

Location

Loc Qty

Loc Code

ST277

67

111275

4

111411

63

MS21043-3

Purchased

No

110

Each

999.0000

4

16

**\*MS21043-3\***

Nut

\*\*

M121255

Location

Loc Qty

Loc Code

FG

72

103691

72

GA

350

120693

350

ST300

84

119901

84

ST301

493

118077

2

118614

441

118686

30

119758

20

MS24693-C280

Purchased

No

110

Each

37.0000

2

8

**\*MS24693-C280\***

Screw

\*\*

M121060

M121060  
12/6/64

Location

Loc Qty

Loc Code

ST289

25

120498

25

ST310

12

118612

12

March-08-12 8:53:27 AM

Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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\*D412-630-033\*

Parent Item Name: Heli Access Step LH Folding

Start Date: 08/03/2012

Required Date: 22/03/2012

Start Qty: 4.00

Required Qty: 4.00

D2806-1 Manufactured No

130 Each

27.0000

\*D2806-1\*

Bushing

\*\*

82033 JB

## Location

## Loc Qty

## Loc Code

ST018

27

78888

2

79527

25

D2806-3 Manufactured No

130 Each

16.0000

\*D2806-3\*

Bushing

\*\*

2x82034 JB  
6x83944

## Location

## Loc Qty

## Loc Code

ST018

16

79528

16

D2810-5 Manufactured No

130 Each

7.0000

\*D2810-5\*

Strut

\*\*

3x82256 JB  
1x83964

## Location

## Loc Qty

## Loc Code

ST265

7

52034

1

79690

6

D3396-1 Manufactured No

130 Each

16.0000

\*D3396-1\*

Spacer

\*\*

82036 JB

## Location

## Loc Qty

## Loc Code

ST041

16

78885

16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Required Date: 22/03/2012

Start Qty: 4.00

Required Qty: 4.00

AN4C6A

Purchased

No

130

Each

358.0000

0

4

\*\*

121656 JB

\*AN4C6A\*

Bolt

Location

Loc Qty

Loc Code

FG

4

103344

4

ST356

354

116704

7

119749

47

120423

200

120521

100

AN4C10A

Purchased

No

130

Each

58.0000

0

4

\*\*

JB

\*AN4C10A\*

Bolt

Location

Loc Qty

Loc Code

ST356

58

112243

2

114523

30

120820

16

120840

10

AN5C15A

Purchased

No

130

Each

78.0000

2

8

\*\*

JB 12/06/13

\*AN5C15A\*

Bolt

Location

Loc Qty

Loc Code

ST338

78

118191

3

119749

20

120422

30

120833

25

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Required Date: 22/03/2012

Start Qty: 4.00

Required Qty: 4.00

AN44C7A

Purchased

No

130

Each

34.0000

0 4

\*\*

\*AN44C7A\*

Eyebolt

Location

Loc Qty

Loc Code

ST362

34

111308

24

120872

10

111308

AN4C15A

Purchased

No

130

Each

239.0000

2 8

\*\*

\*AN4C15A\*

Bolt

Location

Loc Qty

Loc Code

ST358

239

115835

2

118706

37

120360

200

120360

NAS1515H4

Purchased

No

130

Each

173.0000

7 28

\*\*

\*NAS1515H4\*

Washer

Location

Loc Qty

Loc Code

ST277

173

116169

3

117460

1

117735

3

118078

48

118612

9

120120

50

120498

9

120770

50

118078

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Required Date: 22/03/2012

Start Qty: 4.00

Required Qty: 4.00

NAS1515H5

Purchased

No

130

Each

242.0000

7 28 ✓

\*\*

JB

**\*NAS1515H5\***

Washer

Location

Loc Qty

Loc Code

FG

25

103286

5

103691

20

GA

100

120449

100

120449

ST277

117

120299

17

120304

100

MS21043-4

Purchased

No

130

Each

1,257.000

4 16 ✓

\*\*

121162 JB

12/06/13

**\*MS21043-4\***

Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

1217

119546

435

120308

782

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Work Order ID: 81119

\*81119\*

Parent Item: D412-630-033

\*D412-630-033\*

Parent Item Name: Heli Access Step LH Folding

Start Date: 08/03/2012

Required Date: 22/03/2012

Start Qty: 4.00

Required Qty: 4.00

MS21043-5

Purchased

No

130

Each

507.0000

12

\*\*

JB

12/06/13

\*MS21043-5\*

Net

Location

Loc Qty

Loc Code

FG

20

101418

20

ST300

62

112314

62

ST301

425

116548

100

118159

100

119307

25

119537

200

119537

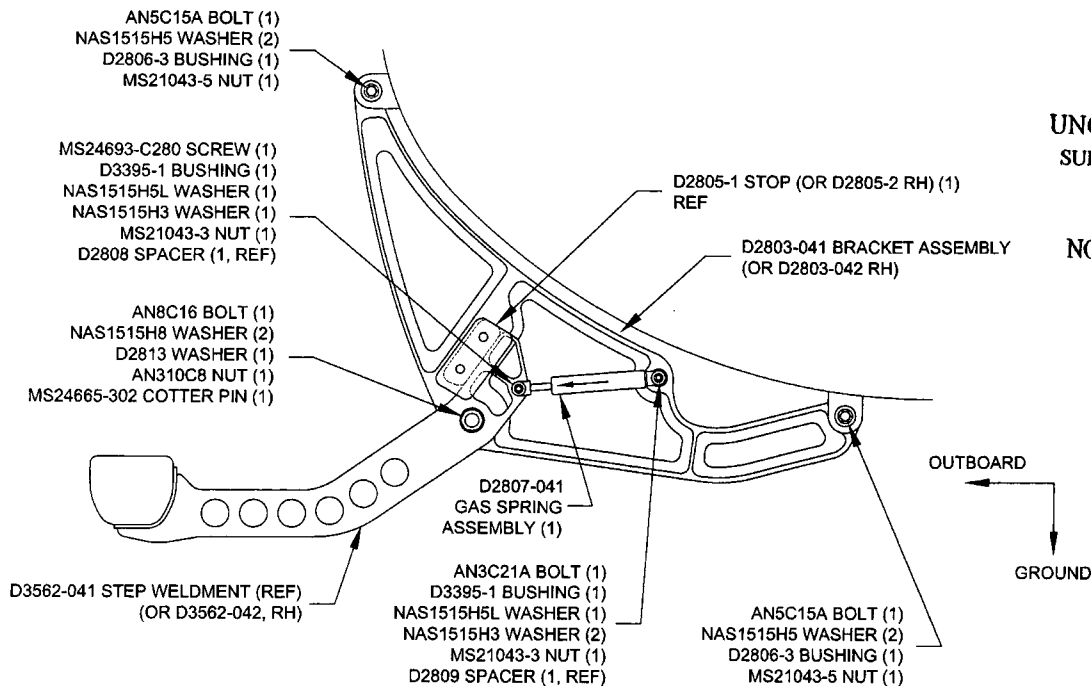
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

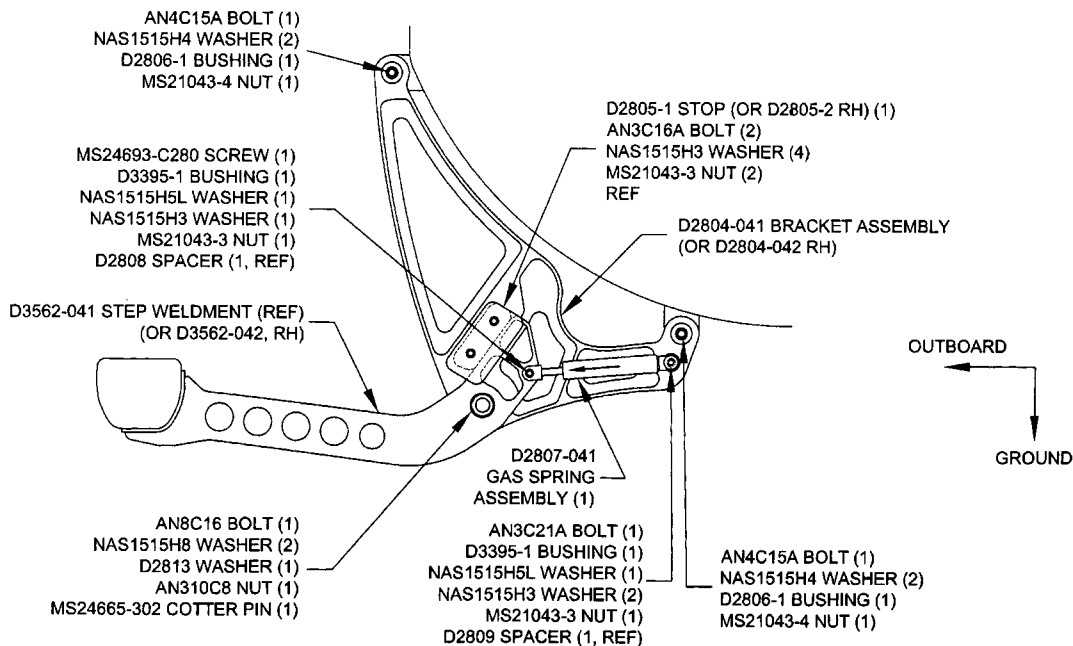
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**D412-630-033/-034 Heli-Access-Step™ Installation**

**FIGURE 14 – STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation  
(View rotated 90° CW)**



**FIGURE 15 – STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation  
(View rotated 90° CW)**

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WITHOUT NOTICE  
WORK ORDER  
NO. 81119 *MLJ*  
12/03/09

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

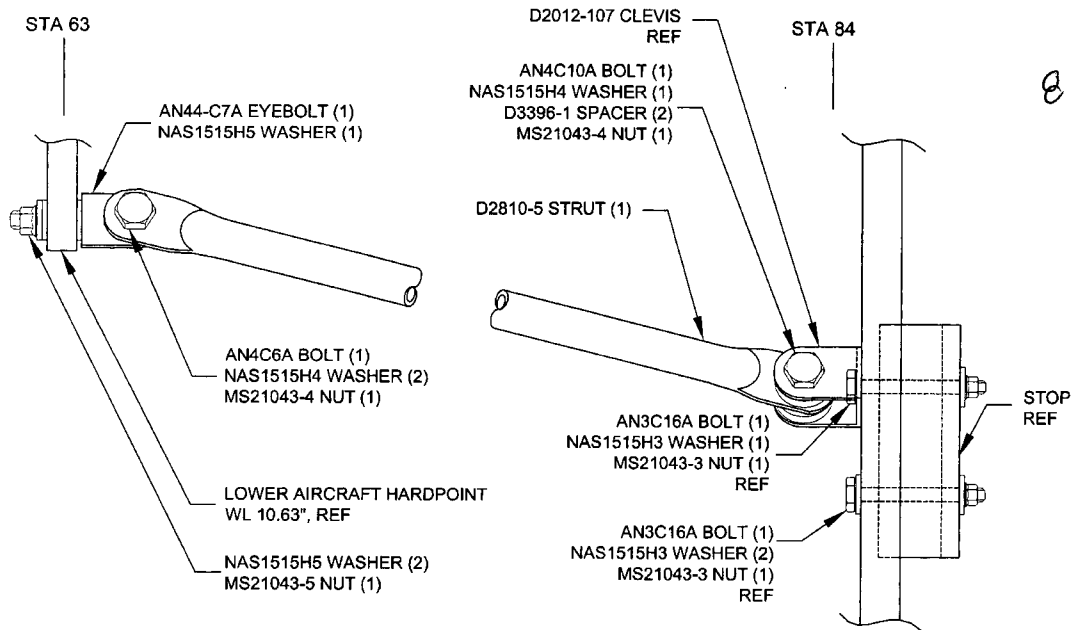


FIGURE 16 – Strut Detail for D412-630-033/-034 *Heli-Access-Step™* Installation  
(NOT TO SCALE)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

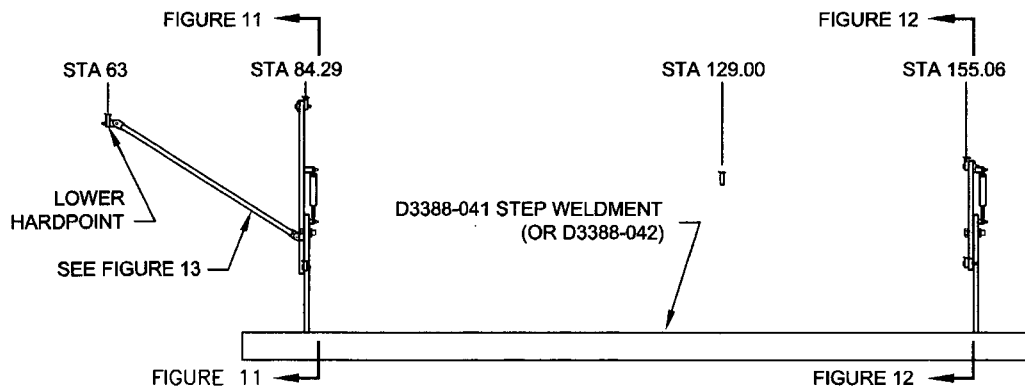
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

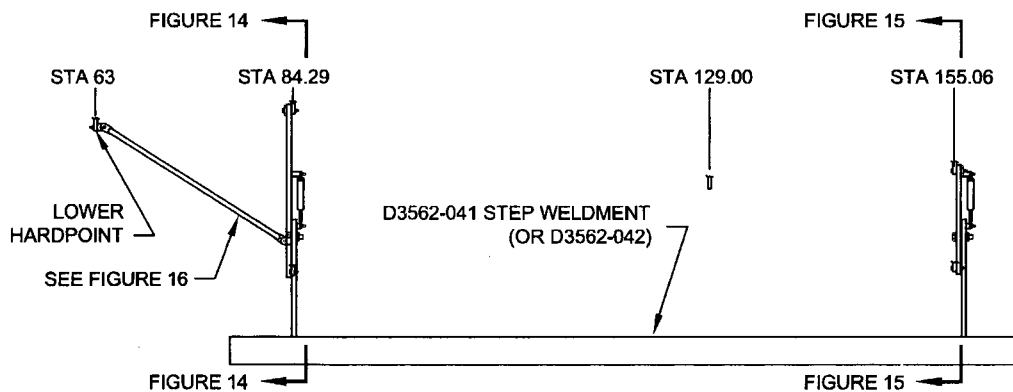
NOTE: Date & initial all entries

Qty -033	Qty -034	Qty -243	Qty -244	Part Number	Description
X				D412-630-033	HELI-ACCESS-STEP™ LH (FOLDING)
	X			D412-630-034	HELI-ACCESS-STEP™ RH (FOLDING)
1		X		D412-630-243	STEP ASSEMBLY LH
	1		X	D412-630-244	STEP ASSEMBLY RH
		1	1	D2012-107	CLEVIS
		1		D2803-041	STA 84 BRACKET ASSEMBLY LH
			1	D2803-042	STA 84 BRACKET ASSEMBLY RH
		1		D2804-041	STA 155 BRACKET ASSEMBLY LH
			1	D2804-042	STA 155 BRACKET ASSEMBLY RH
2	2			D2806-1	BUSHING
2	2			D2806-3	BUSHING
		2	2	D2807-041	GAS SPRING ASSEMBLY (WAS D2807)
1	1			D2810-5	STRUT
		2	2	D2813	WASHER
		1		D3562-041	STEP WELDMENT LH
			1	D3562-042	STEP WELDMENT RH
		4	4	D3395-1	BUSHING
2	2			D3396-1	SPACER
		2	2	AN3C21A	BOLT
1	1			AN4C6A	BOLT
1	1			AN4C10A	BOLT
2	2			AN4C15A	BOLT
4	4			AN44-C7A	EYEBOLT
2	2			AN5C15A	BOLT
		2	2	AN8C16	BOLT
		2	2	AN310C8	NUT
		2	2	MS24665-302	COTTER PIN (OR AN380C3-4)
		6	6	NAS1515H3	WASHER
7	7			NAS1515H4	WASHER
7	7			NAS1515H5	WASHER
		4	4	NAS1515H5L	WASHER
		4	4	NAS1515H8	WASHER
		4	4	MS21043-3	NUT
4	4			MS21043-4	NUT
3	3			MS21043-5	NUT
		2	2	MS24693-C280	SCREW (OR MS24694-C565)

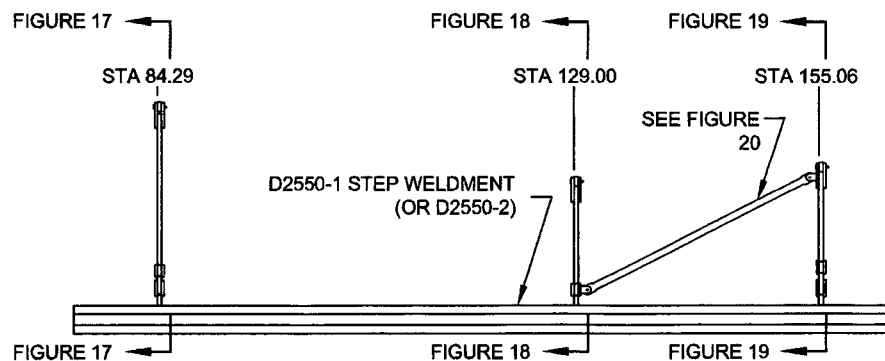
**D412-630-023 HELI-ACCESS-STEP™ LH, FOLDING (SHOWN)**  
**D412-630-024 HELI-ACCESS-STEP™ RH, FOLDING (OPPOSITE)**



**D412-630-033 HELI-ACCESS-STEP™ LH, FOLDING (SHOWN)**  
**D412-630-034 HELI-ACCESS-STEP™ RH, FOLDING (OPPOSITE)**



**D412-630-111 HELI-ACCESS-STEP™ LH, HEAVY DUTY FIXED (SHOWN)**  
**D412-630-112 HELI-ACCESS-STEP™ RH, HEAVY DUTY FIXED (OPPOSITE)**



**FIGURE 3 – D412-630 Heli-Access-Step™ Installations**

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